

Date: Monday, 12/05/2008 9:58:13 AM
User: Julie Lecocq

Dart Aerospace Ltd.

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 39181A
Estimate Number : 10394
P.O. Number :
This Issue : 12/05/2008 S.O. No. :
Prsht Rev. : NC
First Issue : // Type : MACHINED PARTS
Previous Run : 37929A

Drawing Name : STEM

Part Number : D29681
Drawing Number : D2968
Project Number : N/A
Drawing Revision : C
Material :
Due Date : 30/05/2008

Written By

Checked & Approved By : JD 08.5.12
Comment

Est: 03.04.11 Reformat; Incorporated D2968-1/-5 KJ/RF
est D 07.08.23 rev C dwg EC

Qty: 37 Um: Each

Additional Product

Job Number:



WZF No longer use in

Seq. #: Machine Or Operation:

Description :

1.0 M4130NR0750

4130 steel rod .750"



Comment: Qty.: 0.4550 f(s)/Unit Total: 18.1986 f(s)
Material: AISI 4130 Ø 3/4 " Bar
(M4130N-R0.750)
Identify AS D2968-1

Batch: M104452

mmf 08/06/09

2.0 HARDINGE

HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL
1-Turn Blank as per Folio FA047 and Dwg D2968
2-Deburr, no sharp edges

3.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 HAAS1

HAAS CNC VERTICAL MACHINING #1



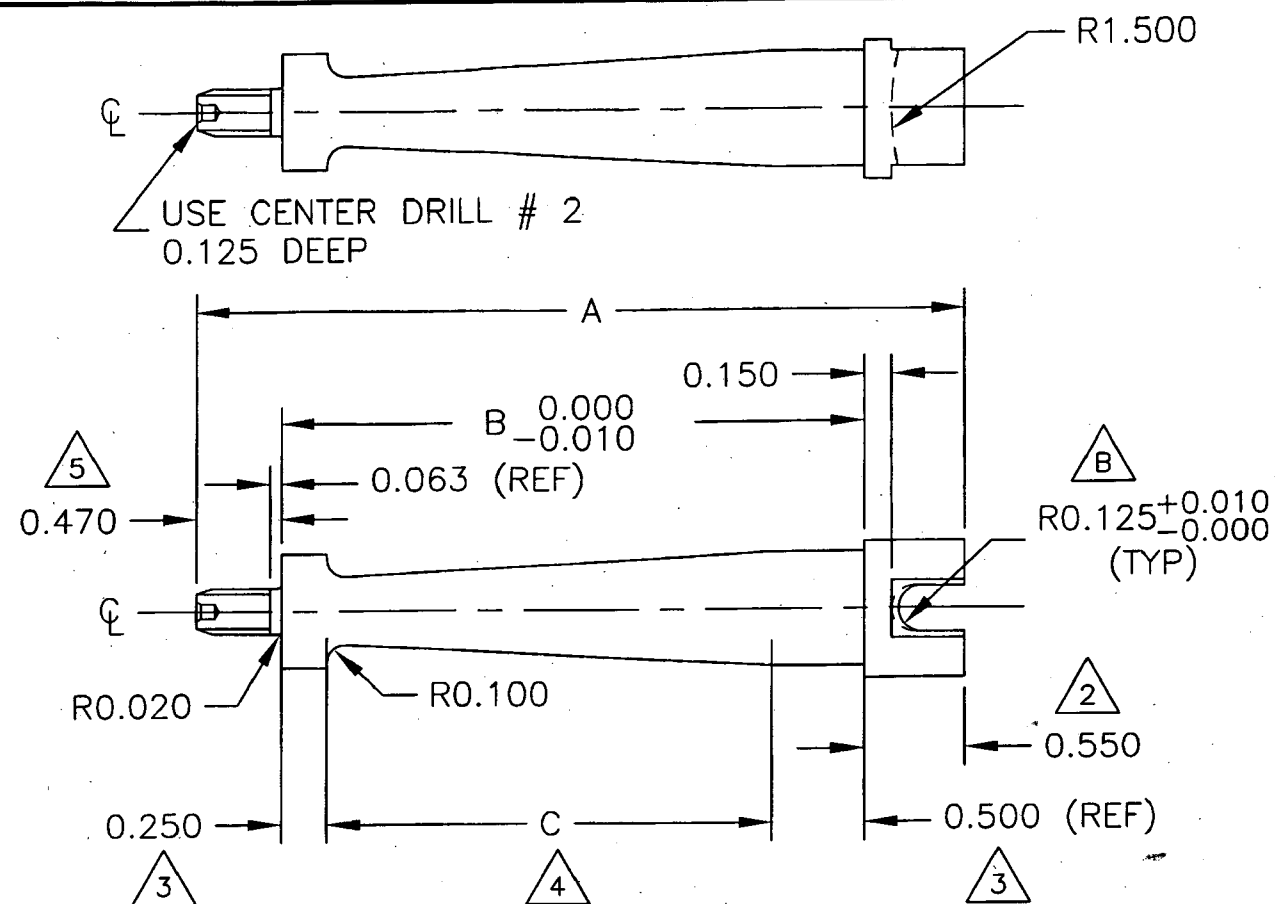
Comment: HAAS CNC VERTICAL MACHINING #1
1- Machine as per Folio FA047 and Dwg D2968
2- Deburr

5.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE



PART NUMBER	A	B	C
D2968-1	5.040	4.020	3.270
D2968-3	4.200	3.180	2.430

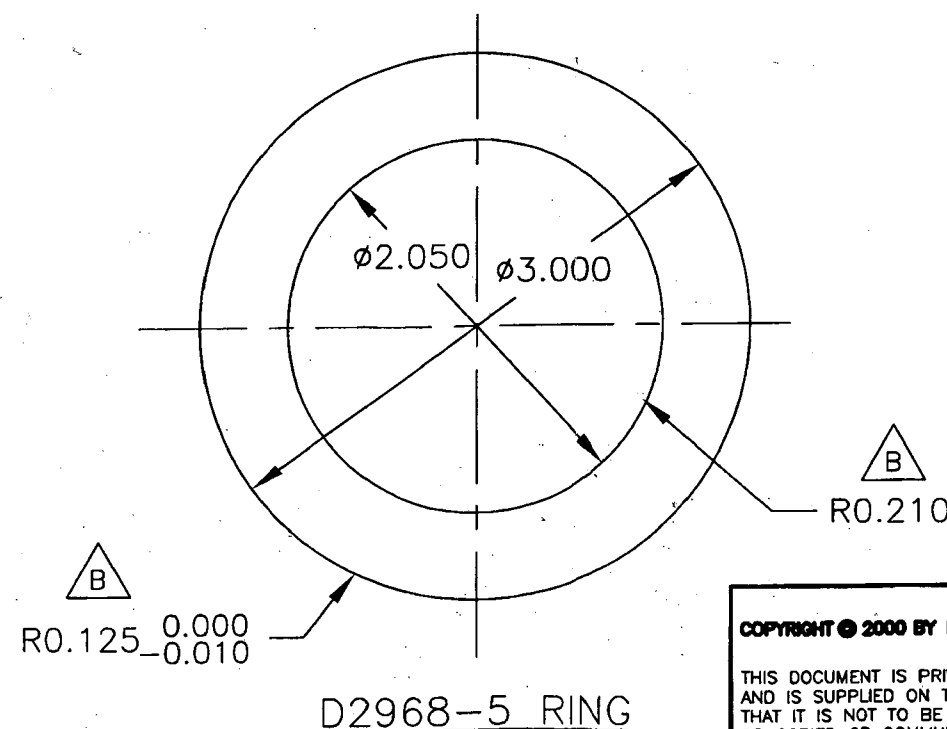
D2968-1/-3 STEM

D2968-1 AND D2968-3 STEM:

- 1) MATERIAL: AISI 4130N ROUND BAR PER MIL-S-6758 OR AMS 6348/6370/6528 (REF DART SPEC M4130N-RX.XXX)
- 2) $\phi 0.750$ O.D.
- 3) $\phi 0.625$ O.D.
- 4) MACHINE UNIFORM TAPER FROM $\phi 0.363$ O.D. TO $\phi 0.625$ O.D.
- 5) 1/4-28 UNF THREAD WITH 0.063 GRIP
- 6) MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS UNLESS OTHERWISE INDICATED
- 7) ALL DIMENSIONS ARE IN INCHES
- 8) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

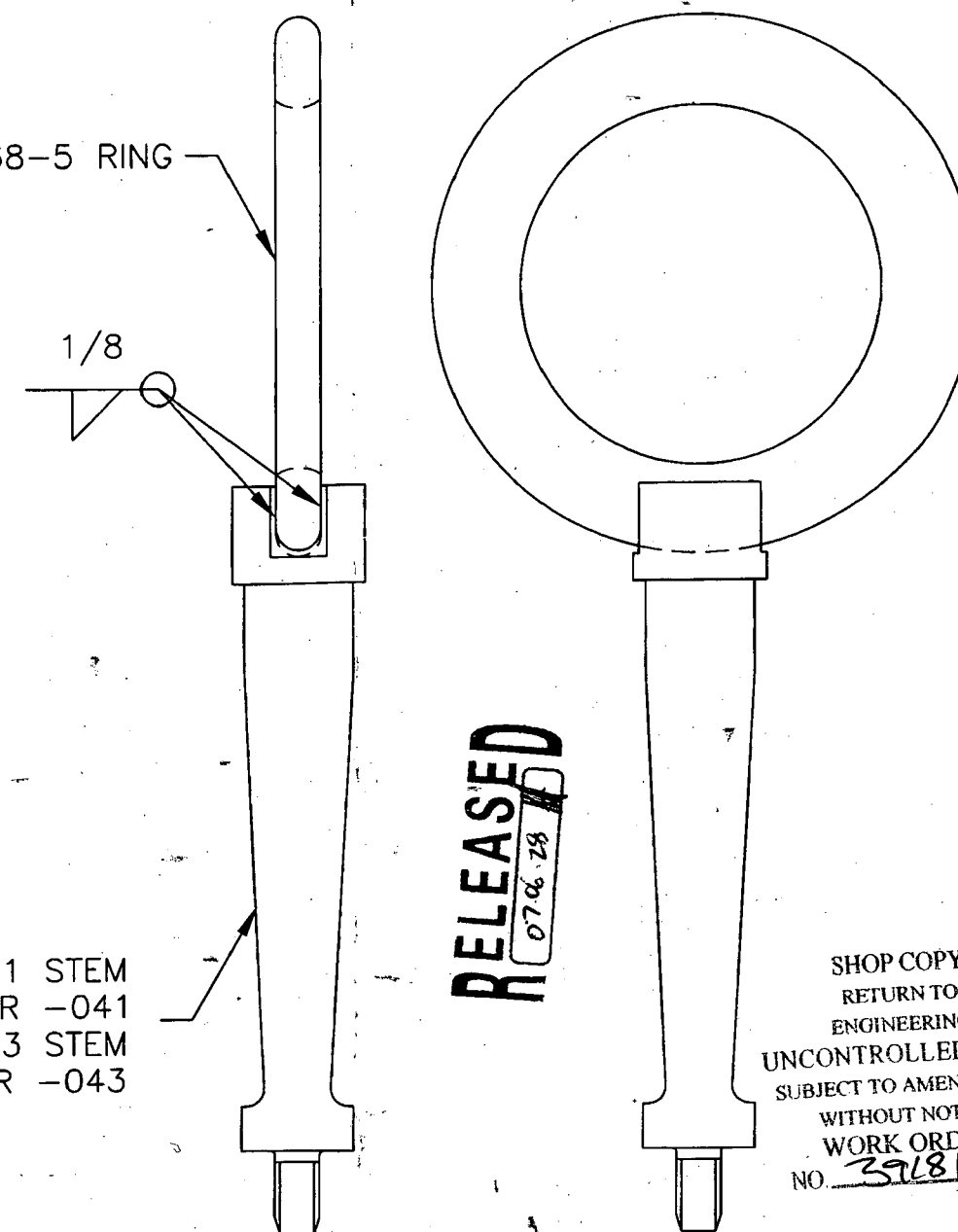
D2968-5 RING:

- 9) MATERIAL: AISI 4130N TUBING PER MIL-T-6736 OR AMS 6360/6361/6362/6371/6373/6374 (REF DART SPEC M4130NT3000W500)
- 10) ALL DIMENSIONS ARE IN INCHES
- 11) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2968-5 RING

D2968-5 RING



USE D2968-1 STEM
FOR -041
USE D2968-3 STEM
FOR -043

D2968-041 AND D2968-043 TOW RING:

- 12) WELD PER QSI 004 ON ALL EDGES BETWEEN STEM AND RING
- 13) HEAT TREAT TO MIN ULTIMATE TENSILE STRENGTH OF 125 KSI
- 14) FINISH: CAD PLATE ENTIRE ASSEMBLY PER QQ-P-416F CLASS I TYPE II POWDER COAT WHITE (REF 4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)

C	07.04.17	2.050 WAS 2.000, UPDATE NOTES
B	00.05.31	R0.125 AND R0.210 WERE 0.060 x 45°
A	00.03.07	NEW ISSUE
DESIGN	PA	DART
CHECKED	PA	DART
DATE	07.04.17	TOW RING
DRAWING NO.	D2968	REV. C
TITLE	TOW RING	SHEET 1 OF 1
SCALE	1:1	

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L Lacelle

From: Bill Beckett [bbeckett@dartaero.com]
Sent: November 13, 2008 6:41 AM
To: 'L Lacelle'
Subject: RE: OLD STEMS FOR TOW RINGS

Linda,
Scrap.
Bill

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: November 12, 2008 3:24 PM
To: 'Bill Beckett'
Subject: OLD STEMS FOR TOW RINGS

We have approx \$2200.00 of the old stems for tow rings (and for some reason machining finished off the last batch end of Oct. !!??) Anyhoooo...do you want to keep and put it at a lower cost in inventory, or just scrap 'em now and get it over with? I suggest scrapping...

LL